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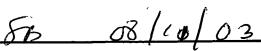
Dart Aerospace Ltd. Monday, 06/10/2008 10:44:58 AM Sate: Julie Lecocq User: **Process Sheet Drawing Name** : SEAT PAN : CU-DAR001 Dart Helicopters Services Customer Job Number : 42444 : 11092 Estimate Number : D30221 Part Number P.O. Number : D3022 REV A **Drawing Number** : 06/10/2008 S.O. No. : This Issue : N/A : NC Project Number Prsht Rev. : LARGE FAB ASSY : // **Drawing Revision** Type First Issue : 37875 Material **Previous Run** : 30/10/2008 Qty: 1 Um: **Due Date** Written By Checked & Approved By NG 02.01.23 Revised Comment : Est. Est Rev:D 08-04-16 now water jet DD verified by:EC **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: 2024-T3 .032 sheet 1.0 M2024T3S032 Comment: Qty.: 1.7044 sf(s)/Unit Total: 1.7044 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3022 8-10-30 Dwg Rev: Prog Rev: *** grind direction along 31.700" *** 2-Deburr if necessary AB 8-10-3C INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 B 8-10-30 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

Comment: SECOND CHECK

NC BRAKE BRAKE NO

Comment: NC BRAKE

1-Form as per Dwg D3022



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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	1:	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCF	1)			
		Description of NC		Corrective Action Secti		Verific	Verification Section C Chief Er	Approval	Approval QC Inspector
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NOTE: Date & initial all entries

Monday, 06/10/2008 10:44:58 AM Date: User: Julie Lecocq **Process Sheet Drawing Name: SEAT PAN** Customer: CU-DAR001 Dart Helicopters Services Part Number: D30221 Job Number: 42444 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 WORK TO CURRENT STEP Comment: INSPECT LARGE FABRICATION RESOURCE 1 LARGE FAB 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Modulos 1-Transfer drill Seat Pan From Frame *****Transfer drill in D3022-1 using D3017-041 ***** 2-Deburr INSPECT WORK/TO CURRENT STEP 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 9.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING POWDER COATING 10.0 106446 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 PACKAGING 1 12.0 Comment: PACKAGING RESOURCE #1 Identify and Stock PPP 42416 Location:

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W/O:			WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Date:

Monday, 06/10/2008 10:44:58 AM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 42444

Part Number: D30221

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



98/41/10AS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-10

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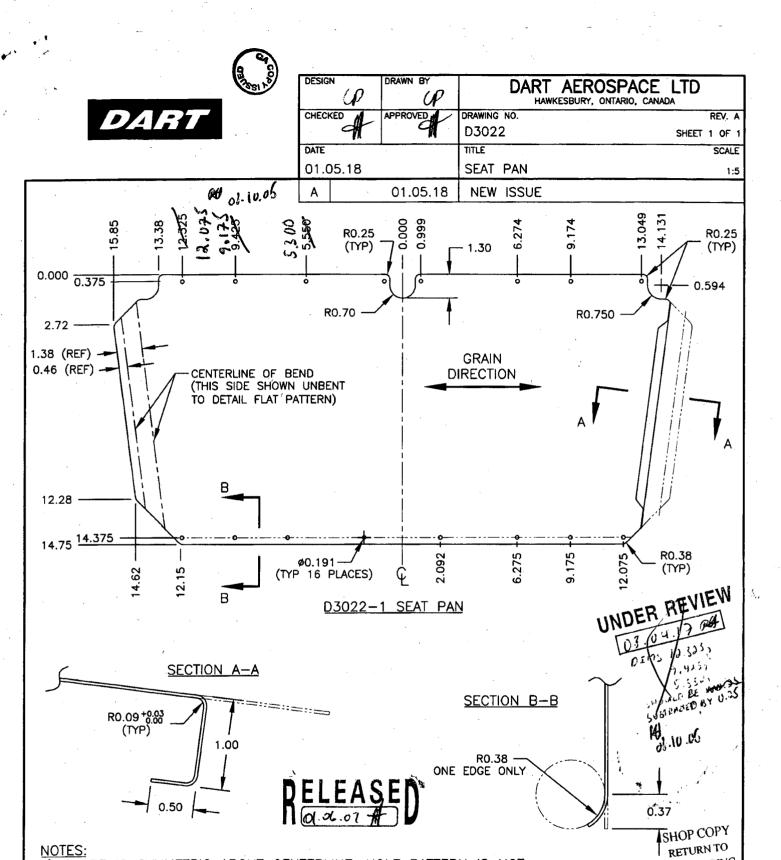
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DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	STEP Description of NC Section A		Corrective Action Section		Verifi	cation	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: L	12444
Description: Seat Pan	Part Number:	D3022-1
Inspection Dwg: D3022 Rev: A		Page 1 of 1

)	First Arti	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		mments
14.75	+/-0.030	14.75	D				
12.28	+/-0.030	86.61	Ø			•	
2.72	+/-0.030	2.15	*				
14.62	+/-0.030	14.67	5			.5	
12.15	+/-0.030	71.61"	¥				
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asured by:	1-B	Audited by:			Prototype A	Approval:	N/A
Date:	8-10-30	Date:	 	7 /		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.06.13	New Issue	KJ/DD of	N/
		1		•



NOTES:

1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT

2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK

FINISH: ACID ETCH & ALODINE PÉR DART QSI 005 4.1

POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

ENGINEERING

UNCONTROLLED

SUBJECT TO AMEND

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